Date:

Friday, 29/08/2008 11:38:33 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41671

Estimate Number

: 10313

P.O. Number

This Issue : 29/08/2008

: NC Prsht Rev. First Issue

: //

: 41611

Type

: SMALL /MED FAB

Part Number

KJ/RF

Drawing Name

: D26483

Drawing Number

. D2648 REV D

: WEARPAD

: N/A **Project Number Drawing Revision**

: D

Material Due Date

: 15/09/2008

Qty:

40 Um:

Each

Written By Checked & Approved By

Previous Run

Comment

: Est: E 02.09.18 Re-format; Incorporated D2648-1

S.O. No. :

Est Rev:F Now on Waterjet 06-08-14

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0788 sf(s)/Unit Total:

3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 105766

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:

Prog Rev:

2-Deburr if necessary

3.0

H3 8-9-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Form: rprocess

counter

Page 1

Dart Aerospace Ltd

	1									
W/O:			W	ORK ORDER	CHANGES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		•			***					
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										ū.
Part No		PAR #:	Fault Cate	gory:	NC	R: Yes	No DQA	:	Date:	
	Re	solution:	Dispositio	n;	Q/	A: N/C Cld	sed:		Date: _	
NCR:		V	VORK ORD	ER NON-CO	NFORMANC	E (NCR)		0	
DATE	STEP	Description of NC		Corrective Act			Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action De	escription Eng	Sign & Date	Section		Chief Eng	QC Inspector
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986		•:								
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:38:34 AM User: Julie Lecoca **Process Sheet** Drawing Name: WEARPAD Customer: CU-DAR001 Dart Helicopters Services Job Number: 41671 Part Number: D26483 Job Number: Sea. #: **Machine Or Operation:** Description: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. \$ 18/09 2-Identify as D2648-3 7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R560Hardcoat M106762 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary 8.0 ecrenter VISUAL INSPECTION OF GROUND WELDS QC10 Comment: VISUAL INSPECTION OF GROUND WELDS 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 POWDER COATING POWDER COATING M106442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 10:30 Am START TIME: 32001= OVEN TEMPERATURE: _ 11:00 Am FINISH TIME: 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 PACKAGING RESOURCE # PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock 08-09 17 Location: FP-17

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								· i · · · ·		
									*	
Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA	N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE	(NCR				
DATE	STEP	Description of NC		Corrective Action Section	on B		Verifi	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
	Į.						1		1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4167
Description: Wearpad	Part Number: D2648-3
Inspection Dwg: D2648 Rev: D	Page 1 of 1

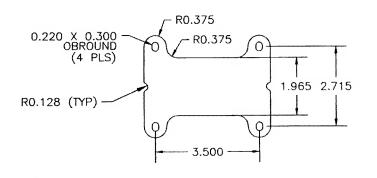
FIRST ARTICLE INSPECTION CHECKLIST

	X	First Articl	е 🗌	Protot	ype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.965	+/-0.010	1967	*			
2.715	+/-0.010	3770	,			
3.500	+/-0.010		b			
0.220 x 0.300	+/-0.010 x +/-0.010	905 XIKC	*			:
R0.375	+/-0.010	1375	*			
R0.128	+/-0.010	.138	*			
						1 - J-12
						

Measured by:	HB	Audited by:	7. '	Prototype Approval:	N/A
Date:	8-9-11	Date:	08/09/4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM 🚓	

D2648-1 FLAT PATTERN



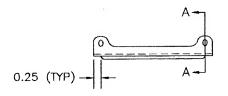
R1.62 — 7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK

SECTION B-B
R1.62
R1.62

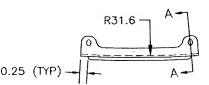
K
0.12 (TYP)
0.13
0.10

D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

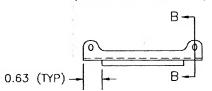
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

		The state of the s
D	99.11.17	ADDED D2648-7
С	97.06.26	R31.6 WAS R19.6
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC
CHECKED	APPROVED	DRAWING NO. REV.
#	#	D2648 SHEET 1 OF
DATE		TITLE SCAL
99.11.17		WEARPAD 1:

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED
BJECT TO AMEND
WITHOUT NOTIC
WORK ORDE